

# PRELIMINARY ISSUE

Work Order ID 63774

Friday, November 12, 2010 1:39:58 PM

Page 1

Item ID: D4277-13

Accept



Setup Start



Revision ID: PRELIM

Item Name: Rib

Stop



Start Date: 11/12/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 2.00

Customer:



Reference:

Approvals:

Process Plan: *mf*

Date: *10-11-12*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4277	PAI

100

0.00



Large Fab

Memo

0.00

- 1- Cut tube at 27.00" with the 60 degree angle
- 2- Remove marking
- 3- On manual bender, bend as per dwg
- 4- Cut to size, 63 degree as per dwg
- 5- Deburr

MATERIAL CERTIFICATION

REQ'D UPON DELIVERY

*10/11/12*



*SAP 10-11-16*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

*8/10/12*



Quality Control

**Work Order ID 63774**

Friday, November 12, 2010 1:39:58 PM

Page 2

Item ID: D4277-13

Accept

Revision ID: PRELIM

Item Name: Rib

Setup Start

Stop

Start Date: 11/12/2010 Start Qty: 2.00

Required Date: 11/17/2010 Req'd Qty: 2.00

Cust Item ID:



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							
Packaging	***STOCK IN BASKET CELL***								
130 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

CMF  
10-11-16

# Picklist Print

Page 1

Friday, November 12, 2010 1:40:03 PM

Work Order ID: 63774



Parent Item: D4277-13



Parent Item Name: Rib

Start Date: 11/12/2010

Required Date: 11/17/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.500W.049

Purchased

No

100

f

400.0256

2.25

4.736842



SAD 10-11-16

Square Tubing

Location

Loc Qty

Loc Code

MAT

104.7831158

114004

0

114807

1.579E-05

115034

104.7831

WA

295.24251

114724

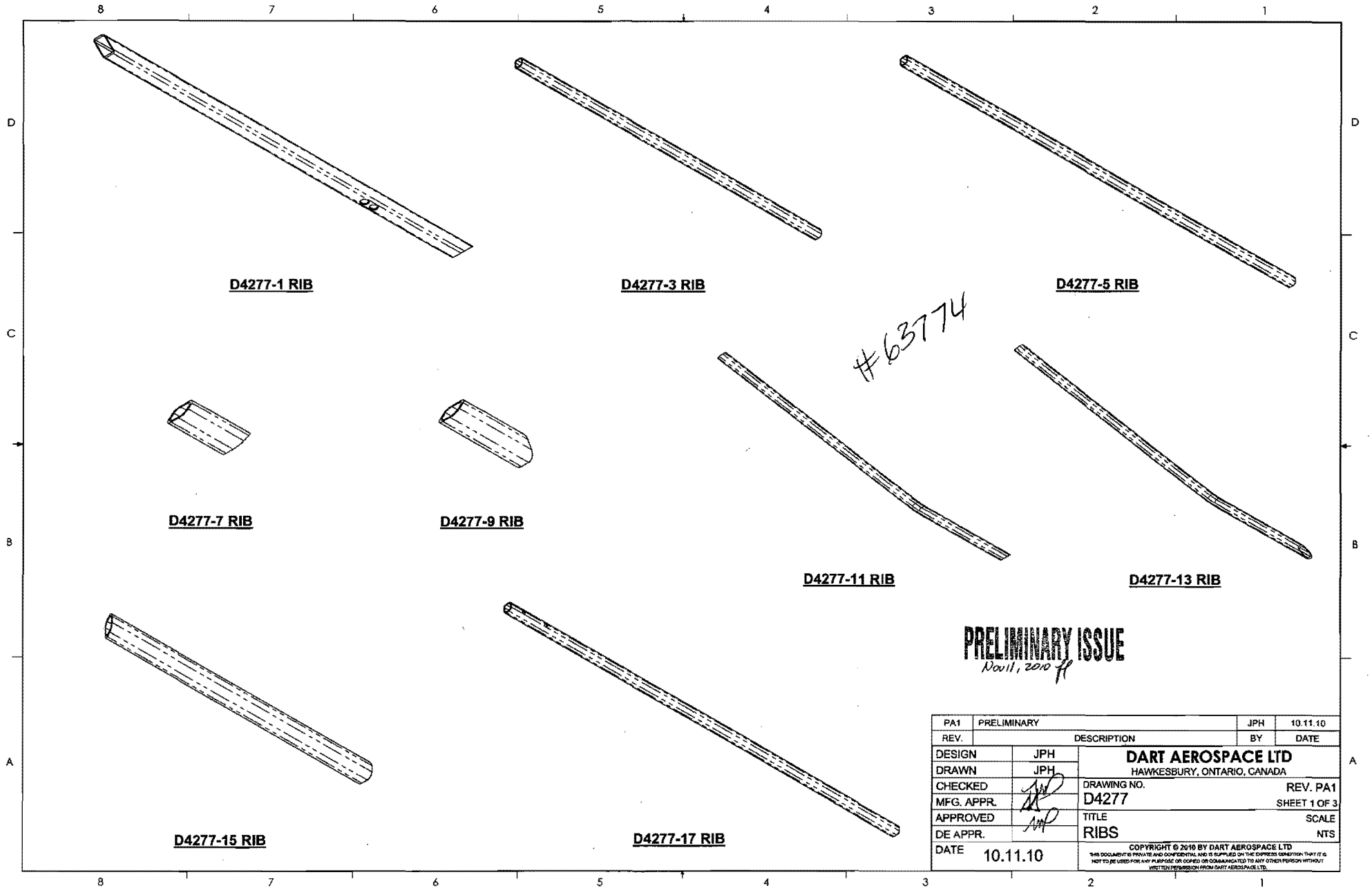
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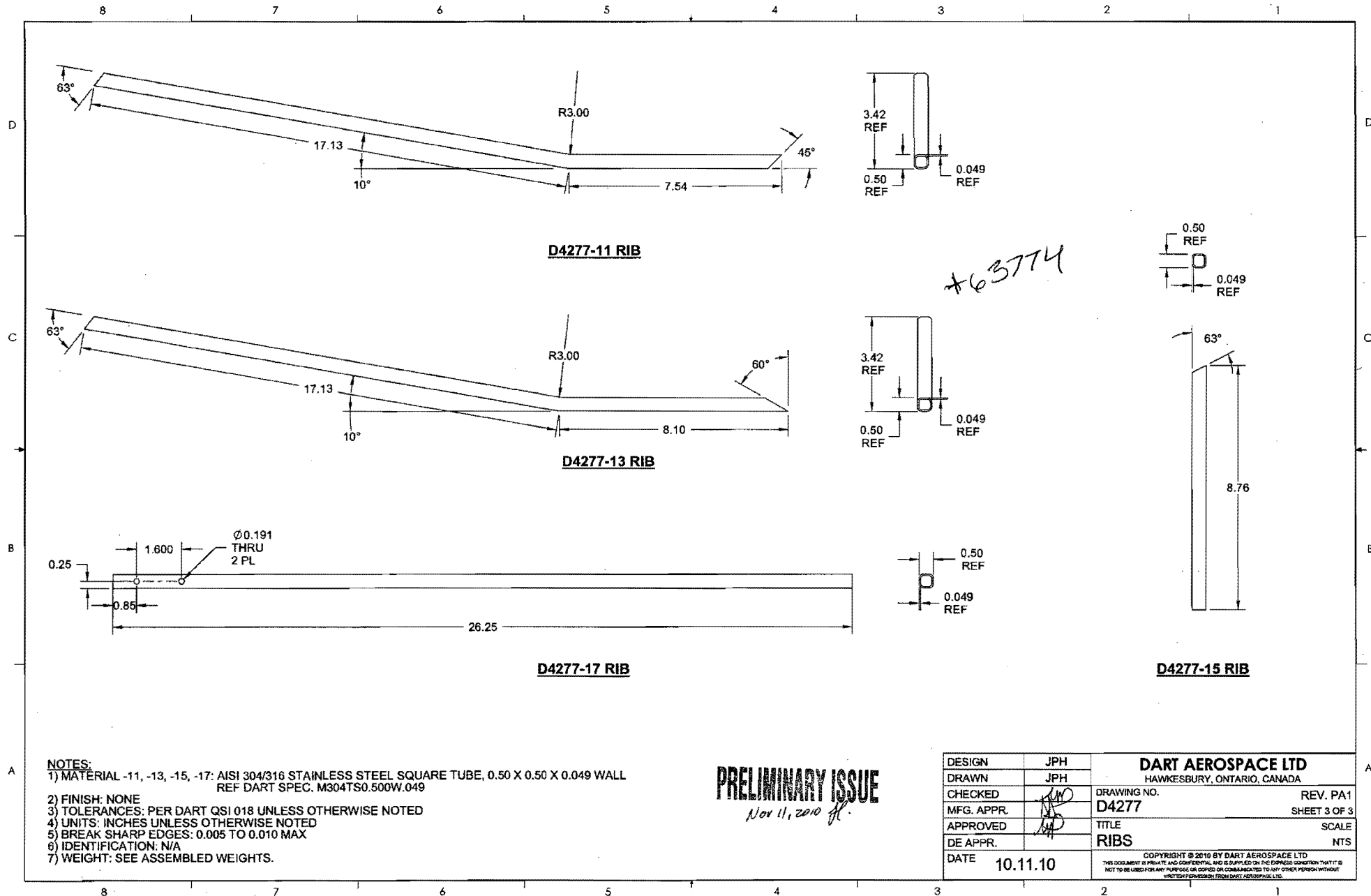
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PA1	PRELIMINARY	JPH	10.11.10
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
MFG. APPR.	<i>[Signature]</i>	D4277	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		RIBS	NTS
DATE	10.11.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



## Receiving Report

Date: 10/7/20 Batch No: M15207  
 Supplier: EAGLE STAINLESS Part P/O: 12186

Packing Slip: Yes ☒ No ☐ Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Invoice: Yes ☐ No ☒ Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Receipt: Cash ☐ Cr ☒ Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order ☐ N/A ☒

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 10/7/20  
 Date [Signature]  
 Received/Costing [Signature]  
 Initial [Signature]

Location \_\_\_\_\_



# EAGLE STAINLESS

Tube and Fabrication, Inc. 10 Discovery Way Franklin Industrial Park Franklin MA 02038

Tel: 800-528-8650, 508-528-8650 Fax: 800-520-1954, 508-520-1954 Email: eagle@eagletube.com Web: www.eagletube.com

## Packing List

Bill Dart Aerospace, Ltd.  
To: 1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada

Ship Dart Aerospace, Ltd.  
To: 1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada

PO Number: PO12156

Shipment No: 76300  
Shipment Date: 07/15/10  
Order Number: 98313  
Order Date: 06/25/10

Customer Code: 000000001912  
Phone: (613) 632-5200  
Terms: Net 30 Days

Ship Via: **FEDERAL EXPRESS**

Quantity						Job
Open	Shipped	Back Ord	Canceled	Unit	Description	Number
312	312	0	0	FT	1912-SQ0500049T304 T304 Smls Square Tubing .500" x .500" x .049" Wall x (30) 117" + .500" / -000 Lengths. As Drawn Temper. Chem to ASTM A269. Certs Required. Pack to Protect.	98313-01

*32 mcy*

This is NOT an Aerospace Application.....





# EAGLE STAINLESS

Tube and Fabrication, Inc

Franklin Industrial Park 10 Discovery Way Franklin, MA 02038

Telephone: (508) 528-8650 or (800) 528-8650 Fax: (508) 520-1954 or (800) 520-1954 Website: www.eagletube.com Email: eagletube@eagletube.com

## MATERIAL TEST REPORT CERTIFICATE OF CONFORMANCE

**SOLD TO:** Dart Aerospace, Ltd.  
**ADDRESS:** 1270 Aberdeen Street  
Hawkesbury ON K6A 1K7  
**DATE:** 7/14/2010  
**PURCHASE ORDER:** PO12156  
**OUR ORDER#:** 98313  
**PART #:** NA  
**REVISION:** NA  
**HEAT #:** J0407-203  
**SOURCE:** 60-40028-07-10  
**ITEM:** .500" X .500" SQ. TUBING X .049" WALL T304 SMLS  
**Spec:** ASTM A269-04/213-04 CHEMISTRY ONLY  
**Temper:** AS DRAWN  
**Quantity:** 312 **Units:** FT

S  
10/02/12

<b>C:</b> .040	<b>Ti:</b> -	<b>Passivation Per ASTM A967:</b> -
<b>Si:</b> .380	<b>Cb:</b> -	<b>Yield (PSI):</b> -
<b>Mn:</b> .930	<b>Ta:</b> -	<b>Tensile (PSI):</b> -
<b>P:</b> .032	<b>Fe:</b> balance	<b>Elong. (% IN 2"):</b> -
<b>S:</b> .001	<b>Cu:</b> -	<b>Hardness (Rockwell):</b> -
<b>Ni:</b> 9.180	<b>Al:</b> -	<b>Flattening:</b> -
<b>Cr:</b> 18.220	<b>N:</b> -	<b>Flaring:</b> -
<b>Mo:</b> -	<b>Co:</b> -	<b>Rev F/B:</b> -
<b>Misc Chem:</b> -		<b>Flange:</b> -
<b>Misc Chem:</b> -		<b>Int C/E:</b> -
<b>Misc Chem:</b> -		<b>Eddy Current:</b> -
		<b>Hydrostatic:</b> -
		<b>Grain Size:</b> -

**Notes:** -

**Notes:** -

**Notes:** -

**Comments:**

Conforms to all drawing and/or specification requirements. To the best of our knowledge the material is mercury free, and compliant with Directive 2002/95/EC and 2006/122/ECOF regarding the Restriction of Hazardous Substances (RoHS). Reports governing this material are on file.

*Bernie Pearson*

EAGLE STAINLESS TUBE AND FABRICATION INC.  
Bernie Pearson  
Quality Assurance Manager

*TK*

Int.

7/14/2010

Date



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO12156

Purchase Order Date 6/24/10

PO Print Date 6/25/10

Page Number 1 of 1

Order From :

VU-EAG001

EAGLE STAINLESS  
10 DISCOVERY WAY  
FRANKLIN, MA  
US

RECEIVED

Contact Name  
Vendor Phone 800 528 8650  
Vendor Fax 800 520 1954  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency USD  
FOB

FAKED

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304TS0.500W.049	Square Tubing	7/30/10 Yes	300.00 f	FedEx Pl ppd	\$6.5200	\$1,956.00

Special Inst: MATERIAL: AISI 304/316  
SEAMLESS STAINLESS STEEL  
SQUARE TUBING AS PER ASTM  
A554 MILL FINISH OR  
ASTM A269 MILL FINISH

Nec 312

PO 10/17/20

PO Total: \$1,956.00

Change Nbr: 2

Change Date: 6/25/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

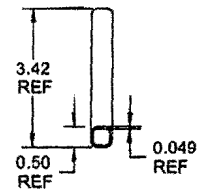
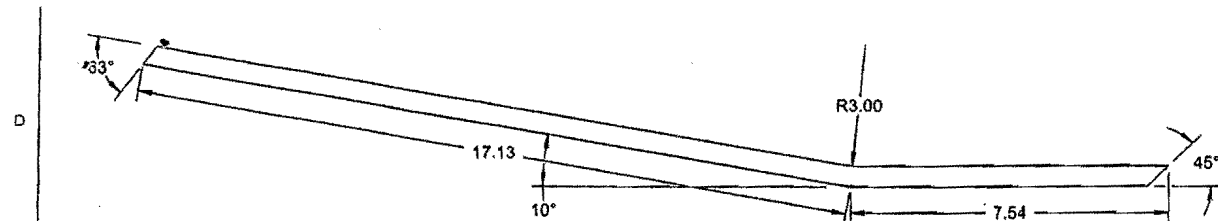
## Page 1 of 1

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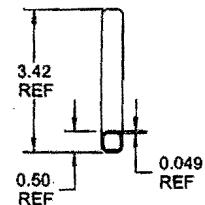
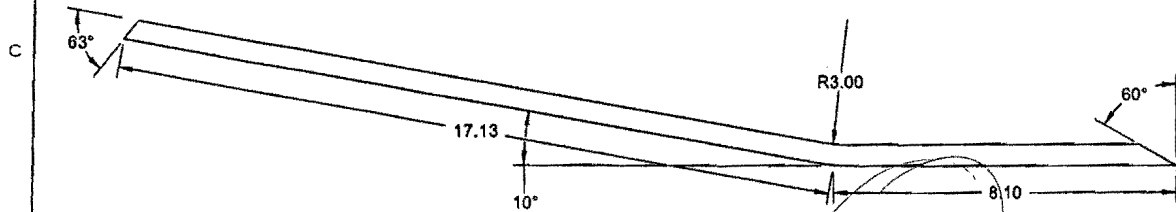
All Item ID/GL/WOs    All Rec. Employees    All Currencies

Grouped by Vendor ID

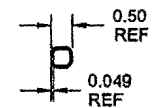
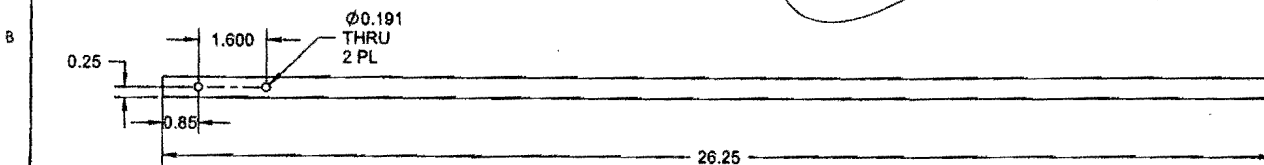
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Total Reject Quantity:	0.0000
Total Receipt Value:	\$2,145.31
Total Balance Due Quantity:	0.0000



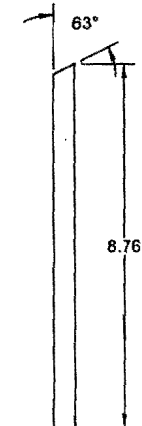
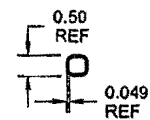
**D4277-11 RIB**



**D4277-13 RIB**



**D4277-17 RIB**



**D4277-15 RIB**

**NOTES:**

- 1) MATERIAL -11, -13, -15, -17: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	<b>D4277</b>	SHEET 3 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	<b>RIBS</b>	NTS
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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